

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003335**Date Inspected:** 30-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** Scott Reed**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K components**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Danny C. White (B89) was present at Oregon Iron Works (OIW) for the purpose of monitoring fabrication operations of the Hinge K Pipe Beam at the OIW fabrication and welding shop in Clackamas, Oregon.

The QA Inspector performed random observations in the fabrication shop (Bay #1). The QA Inspector observed machinist Mr. Scott Jones was machining on the Base-plate component marked a110 for this job on the 30 foot planer mill. Mr. Jones informed the QA Inspector that the plate mentioned above will have the designation a110-1.

The QA Inspector randomly observed that third party Quality Control (QC) Inspector Mr. Scott Reed was monitoring welder qualification tests being performed by Welding OIW Welding Operators. The QA Inspector observed that (12) welding operators so far have performed welding qualification testing with submerged arc welding (SAW) and flux cored arc welding (FCAW). The QA Inspector observed that the samples mentioned above have been placed on a pallet and Mr. Reed informed the QA Inspector that the test plates are awaiting further qualification testing. See photo below for additional information.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

The QA Inspector contacted the Quality Control Manager Mr. Tom Tomovick by telephone and informed him that the 100 millimeter ASTM A709 Grade HPS485W check sample (heat number D4848-6A) which was sent to Translab for testing has failed to meet the minimum yield strength requirements.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

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**Inspected By:** White,Danny

Quality Assurance Inspector

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**Reviewed By:** Wright,Mark

QA Reviewer